

Work Order ID 69779 - 8. *Split*

Thursday, May 19, 2011 8:55:58 AM



Page 1

Item ID: D4360-041.1 *(1)*

Accept



Setup Start



Revision ID:

Item Name: Wearplate Assembly

Stop



Start Date: 5/19/2011 Start Qty: 20.00



Required Date: 5/24/2011 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *P*

Date: 11-05-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4360

B

100

0.00



Waterjet

FLOW CNC Waterjet

*304.03*

Memo

0.00

1-Cut as per Dwg. (D4360-1)

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

*RB 11-5-19*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*RB 11-5-19*

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

8 11/07/10

counters  
(XZ)

130



Large Fab

Large Fab

Memo

1- Weld cups as per dwg  
A/R S.S. ROD BATCH:

2- Apply hardfacing on wear plate as indicated on dwg  
A/R HARDCOAT 2059B BATCH:

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

0.00

0.00

140



QC

Quality Control

W/O: 69779-2

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-07-79	30	stock 1 x D4360-1 under same B/N 69779	W	11-07-79	1	W 11-07-79	

Part No: D4360-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 69779

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Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

160



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W. W. 7/9

# Picklist Print

Page 1

Thursday, May 19, 2011 8:56:04 AM

Work Order ID: 69779



Parent Item: D4360-041



Parent Item Name: Wearplate Assembly

Start Date: 5/19/2011

Required Date: 5/24/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

194.8000

0.97867

20.60358



11-5-19

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

194.8

117275

34.8

117653

160

D4379-1

Manufactured

No

130

Each

0.0000

12

240



182

61

Wearplate Cup

B69780

B70685

11-07-11 JBL  
11-07-12 JBL




ITEM	QTY	P/N	DESCRIPTION
	X	D4360-041	206L/407 WEARPLATE ASSEMBLY
1	1	D4360-1	206L/407 WEARPLATE
2	12	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT

SHOP COPY  
RETURNING  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *69229*

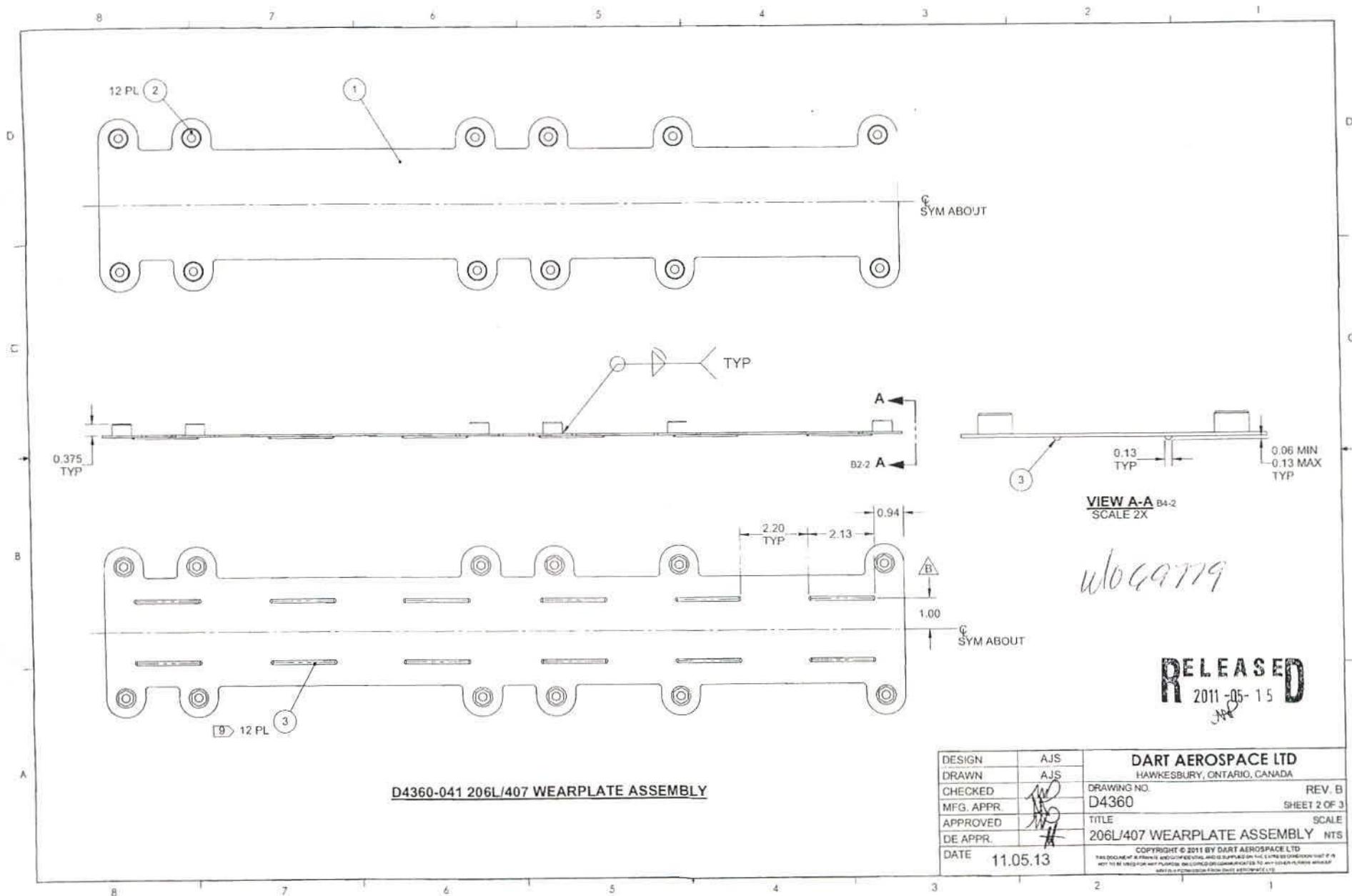
**RELEASED**  
2011-05-15  
*WJ*

**D4360-041 206L/407 WEARPLATE ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4360-041" AND B/N "BXXXXX"  
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.10 lbs
- 8) WELDING: PER QSI 004 
- 9) 2059B HARDCOAT WELD, 12 PL

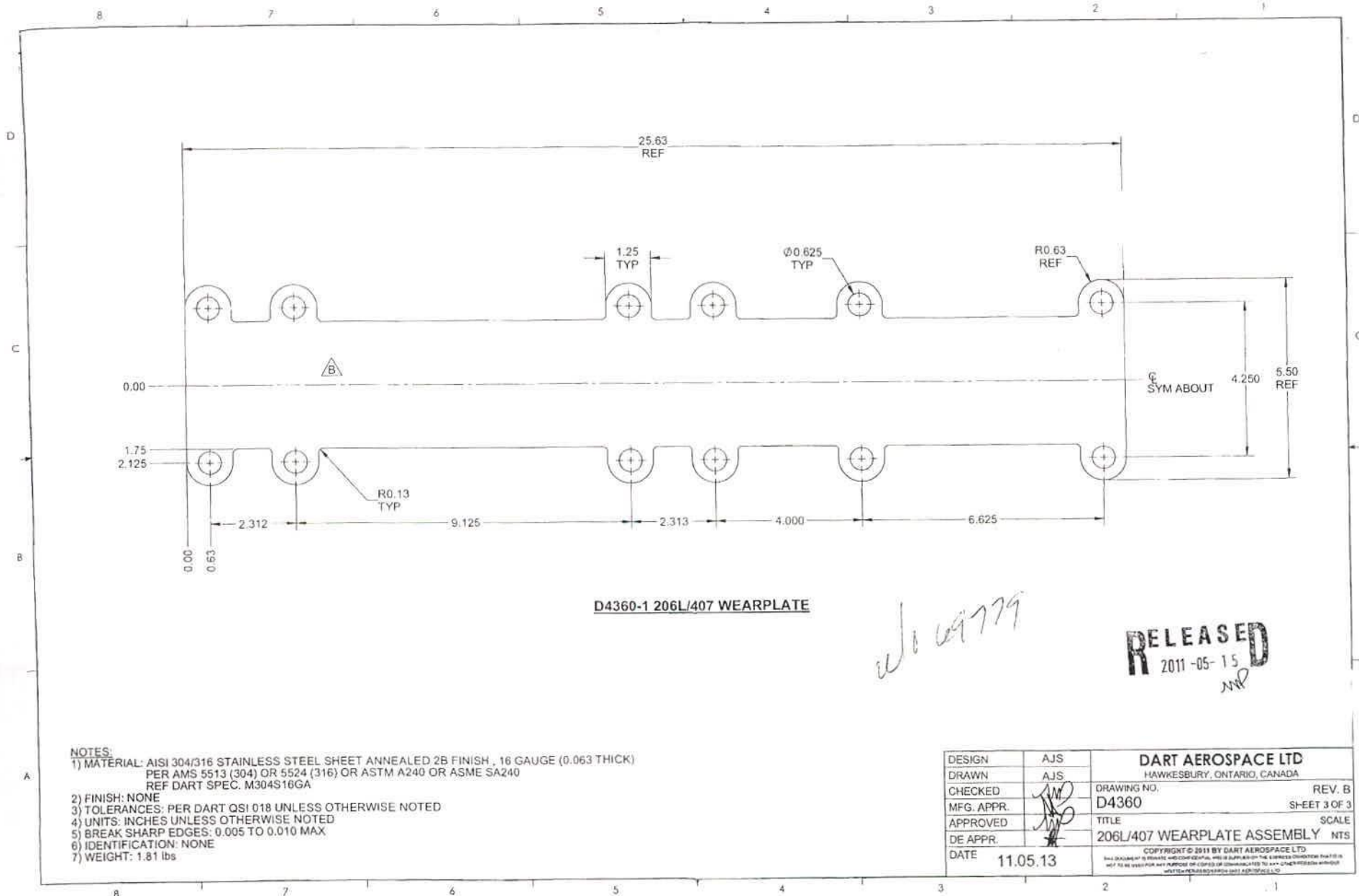
B	SHT 3, LIGHTENING HOLES DELETED, SHT 2 ZONE B,3 HARDCOAT RELOCATED REASON: PROTECTION OF BEARPAW	AJS	11.05.13
A	NEW ISSUE	AJS	11.03.22
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.05.13		
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DRAWING NO. D4360		REV. B	
TITLE		SHEET 1 OF 3	
206L/407 WEARPLATE ASSEMBLY		SCALE	
		NTS	
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**D4360-041 206L/407 WEARPLATE ASSEMBLY**

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MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>206L/407 WEARPLATE ASSEMBLY</b>	
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